

Work Order ID 52867



Page 1

October 16, 2009 10:06:32 AM

Item ID: D206-642-541

Accept



Setup Start



Revision ID: M

Stop



Item Name: Replacement Skidtube

Start Date: 16/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: BTDate: 09-10-16

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

IIN-D206-642

Rev M

100

0.00



DOCUMENT CONTROL

DC

0.00

Memo

Document Control

Photocopy bluefile & type labels per PPP D206-642-541 CHG003

N/A

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Customer:

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Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

110



Skidtubes

Skidtubes

0.00

0.00

Memo

1- Bend FWD end of tube using bend prog D3274 FWD dwg D3274, cut fwd end of tube with saw table setup D3274.

2- remove fwd indexing ridge as per dwg D3274. Prepare for welding

3- weld fwd cap as per dwg D3274 and QSI004

-AR Aluminum Rod Batch: M109213

4- grind fwd cap weld on top surface only

5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end

6-Drill Aft cap pilot hole using DT8025

7 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D.
Drill 3/16" pilot holes as per Dwg D3274

8 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch #

9 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

DP 9-10-19

- AHM 7-10-21

BE 9-10-21

BE 9-10-21

H 9-10-22

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Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

SPD 09-10-22

①

Hand Finishing

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

27 S 09/10/26

②

9

Quality Control

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

27 S 09/10/26

③

6

Quality Control

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

150

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open Ø0.313" and 0.375" crossbolt spacer holes using DT8743 as per Dwg D3274

2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

3-Bond web in place as per Dwg D3274 & QSI 015.

A/R ☐ Sikaflex-291 ☒ 5/12/29 ☐

Sikaflex expire date: ☐ 10/12/30 ☐

Start: ☐ 9/10/29 Time: ☐ 2:55 ☐

Finish: ☐ 9/10/30 Time: ☐ 10:00 AM

(Adhere for 12 hours)

AWM 9-10-26

1 M 9/10/29

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

5/10/30

⊙

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Cust Item ID:

Required Date: 32/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170



Skidtubes

Skidtubes

0.00

0.00

Memo

1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.

2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-IT2
OPEN HOLES TO .297" . Deburr3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT895 FWD
END OF TUBE
DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE-HOLES)
REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

4- Countersink crossbolt spacer holes as per Dwg D3274

5- prepare for welding

DP 9-11-2

P70

11/9/11/4

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Memo

2) Sorkulov



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D206-642-541 PAR #: NP Fault Category: Skidhebes NCR: Yes No DQA: NA Date: 09.12.08
 Resolution: Accepted Disposition: Use as is QA: N/C Closed Date: 08.12.11

NCR: <u>52867</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09.11.03</u>	<u>170</u>	<u>AFT BEND IS 3.4"</u> <u>L° = 5.4° from bending</u> <u>P.C. process.</u>	<u>[Signature]</u> <u>09.11.03</u> <u>pu</u> <u>QSI 042</u>	<u>Acceptable</u>	<u>M</u> <u>9/11/4</u>	<u>S</u> <u>orluloy</u>	<u>[Signature]</u> <u>09.11.03</u> <u>pu</u> <u>QSI 042</u>	<u>S</u> <u>orluloy</u>

NOTE: Date & initial all entries

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Customer:

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod A/R <input type="checkbox"/> Aluminum Rod <u>M112507</u> <u>BE 09/11/05</u>								
	3-Grind cross bolt welds flush as per Dwg D3274.								
	4-Counterbore 5/16" x 0.750" deep as per Dwg D3274. Use DT8743 visual aid Jig and deburr.								
200 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

AWM 9-11-10

1 105-11-11

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

210

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

1 PS-11-11

220

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

20 Ø

230

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

11/12/08

START TIME: 8:15AM
OVEN TEMPERATURE: 320°C
FINISH TIME: 8:45AM

=> JM 08/11/10

21 Ø

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Setup Start



Stop



Start Date: 16/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									
250	HandFinishing	0.00							
HandFinish	Memo	0.00							
Hand Finishing	1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets. A/R <input type="checkbox"/> N/A <input type="checkbox"/> LPS-3 <input type="checkbox"/> <u>u/a</u>								
	2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a A/R <input type="checkbox"/> Sikaflex-291 <input type="checkbox"/> <u>m11239</u> Sikaflex expire date: <input type="checkbox"/> <u>10/20</u>								
260	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control	Inspect Nut Plate & Inserts								

MO 09/11/18

XI

XI

MO 09/11/18

2) 07/11/18

(4) 6

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Required Date: 02/11/2009 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

270



HandFinish

Hand Finishing

HAND FINISHING RESOURCE #1

0.00

0.00

Memo

1-Install wearpads & gaskets as per Dwg D3274.

2-Install ring as per Dwg D3274

A/R ☐ Sikaflex-291 ☐ M1123H ☐

Sikaflex expire date: ☐ 10/20

3-Inspect for foreign objects as per QSI 024

4-Spray inside of tube on both sides of web with LPS-3

A/R LPS-3 Batch: N/A

5-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/R ☐ Sikaflex-291 ☐ M1123H ☐

Sikaflex expire date: ☐ 10/20

MD 09/11/19

XI

280



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Memo

JS 09/11/19

FD

P

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

290

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

PPP 52876

0.00

Packaging

09/12/2009

300

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/03

MF 09-12-02

Picklist Print

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Page 1

Work Order ID: 52867

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 16/10/2009

Required Date: 02/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2600-1-190RevD1 Manufactured No

110 Each 65.0000

1.0000



Extrusion Round 3" 206

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

65

47575

65

110 Each 27.0000

1.0000

D3285-1RevA

Manufactured No



Cap

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

27

47635

27

150 Each 5.0000

1.0000

D3282-041RevC

Manufactured No



Float Web (206L/407)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

5

48389

5

52696

1 9/10/29

9-10-19

DE 09/10/21

Picklist Print

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Work Order ID: 52867



Parent Item: D206-642-541RevM



Parent Item Name: Replacement Skidtube

Start Date: 16/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2649RevB1

Manufactured

No

190

Each

593.0000

12.0000



Cross Bolt Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

83

51529

83

Main Warehouse

ST

510

36013

5

47112

383

48271

122

12

BE 09/11/05

D3275-1RevA1

Manufactured

No

190

Each

28.0000

12.0000



Crossbolt Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

28

47464

1

48117

15

48270

12

12

BE 09/11/05

Q 52510

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Page 3

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Required Date: 02/11/2009

Comments:

Start Qty: 1.00

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---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

CR3212-4-03

Purchased

No

250

Each

310.0000

2.0000



Cherry Rivet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

310

111359

96

112314

200

15984

14

250

Each

93.0000

1.0000

D3415-041RevB

Manufactured

No



Nut Plate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

93

33842

93

250

Each

267.0000

2.0000

CCR264SS3-3

Purchased

No



Cherry Rivet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

267

111548

52

111827

115

112314

100

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

ALS4-1032-130

Purchased

No

250

Each

5,373.000

78.0000



Insert

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

5373

110511

5373

270

Each

41.0000

1.0000

D3536-15RevA

Manufactured

No



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

41

47711

3

48159

12

51600

26

X 78 MD 09/11/18

X 1 MD 09/11/18

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Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3536-23RevA

Manufactured

No

270

Each

30.0000

1.0000



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

12

51609

12

Main Warehouse

ST

18

30754

1

47713

17

XL MD 09/11/08

D3536-35RevA

Manufactured

No

270

Each

39.0000

1.0000



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

39

48160

13

51628

26

XL MD 09/11/08

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Start Qty: 1.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3536-39RevA

Manufactured

No

270

Each

28.0000

1.0000



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

12

51637

12

Main Warehouse

ST

16

44648

1

47714

4

48161

11

270

Each

31.0000

1.0000

D3535-15RevB

Manufactured

No



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

18

51671

18

Main Warehouse

ST

13

30750

4

42233

1

48155

8

XI MD 09/11/18

XI MD 09/11/18

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Comments:

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---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3535-35RevB

Manufactured

No

270

Each

36.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

36

48157

10

51608

26

270

Each

26.0000

1.0000

D3535-39RevB

Manufactured

No



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

13

51619

13

Main Warehouse

ST

13

48158

13

X1 mo 09/11/18

X1 mo 09/11/18

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Work Order ID: 52867



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Required Date: 02/11/2009

Comments:

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3535-23RevB

Manufactured

No

270

Each

24.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

13

51618

13

Main Warehouse

ST

11

48156

11

53467

xl mo 09/11/19

D3537-3RevC

Manufactured

No

270

Each

69.0000

1.0000



Wearpad

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

69

30758

7

33881

17

35697

45

xl mo 09/11/18

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October 16, 2009 10:06:37 AM

Work Order ID: 52867

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 16/10/2009

Required Date: 02/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item #/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3537-1RevC		Manufactured	No			270	Each	284.0000	9.0000			
Wearpad												

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
FP	2	
48288	2	
Main Warehouse		
FP17	265	
51624	103	
51678	162	
Main Warehouse		
ST	17	
51918	17	

X9 mo 09/11/18

AN960C10L

washer

Purchased

No

270

Each

4,396.000

80.0000

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
OFFSHORE		
FG	100	
103585	100	
Main Warehouse		
ST	4296	
112116	993	
12612	3303	

X80 mo 09/11/18

October 16, 2009 10:06:37 AM

Shop Packet Print

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Picklist Print

October 16, 2009 10:06:37 AM

Work Order ID: 52867



Parent Item: D206-642-541RevM



Parent Item Name: Replacement Skidtube

Start Date: 16/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN960C416

Purchased

No

270

Each

704.0000

1.0000



washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

704

100993

704

270

Each

2,056.000

2.0000

D3672-1RevB

Manufactured

No



Phenolic Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1556

39275

19

42329

15

47628

522

52505

1000

Main Warehouse

ST117

500

51674

500

X1 MO 09/11/18

X2 MO 09/11/18

Picklist Print

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October 16, 2009 10:06:37 AM

Work Order ID: 52867

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube

Start Date: 16/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Serials
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	---------

AN3C4A		Purchased	No			270	Each	1,826.000	80.0000			
--------	--	-----------	----	--	--	-----	------	-----------	---------	--	--	--



BOLT

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	1826	
	112314	40	
	112720	124	
	112724	178	
	112794	984	
	112829	500	

AN4C5A		Purchased	No			270	Each	601.0000	1.0000			
--------	--	-----------	----	--	--	-----	------	----------	--------	--	--	--



BOLT

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	601	
	104936	19	
	110552	80	
	112243	500	
	18918	2	

X80 MD 09/11/18

X1 MD 09/11/18

October 16, 2009 10:06:37 AM

Shop Packet Print

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Picklist Print

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October 16, 2009 10:06:37 AM

Work Order ID: 52867

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 16/10/2009

Required Date: 02/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2646RevC

Manufactured

No

270

Each

53.0000

1.0000



Aft Cap

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

53

20208

0

43801

1

46327

4

48109

48

D3413-1RevA

Manufactured

No

270

Each

40.0000

1.0000



Ring

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

20

48123

20

Main Warehouse

ST473

20

51586

20

XI mo 09/11/18

XI mo 09/11/18

October 16, 2009 10:06:37 AM

Shop Packet Print

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DART

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07.02.12

~~DECLASSIFIED~~

DESIGN CP	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3274	REV. D SHEET 1 OF 4
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY	SCALE NTS
A	04.03.15	NEW ISSUE	
B	04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76	
C	05.03.16	ADD -043; NEW INSERTS	
D	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET	

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

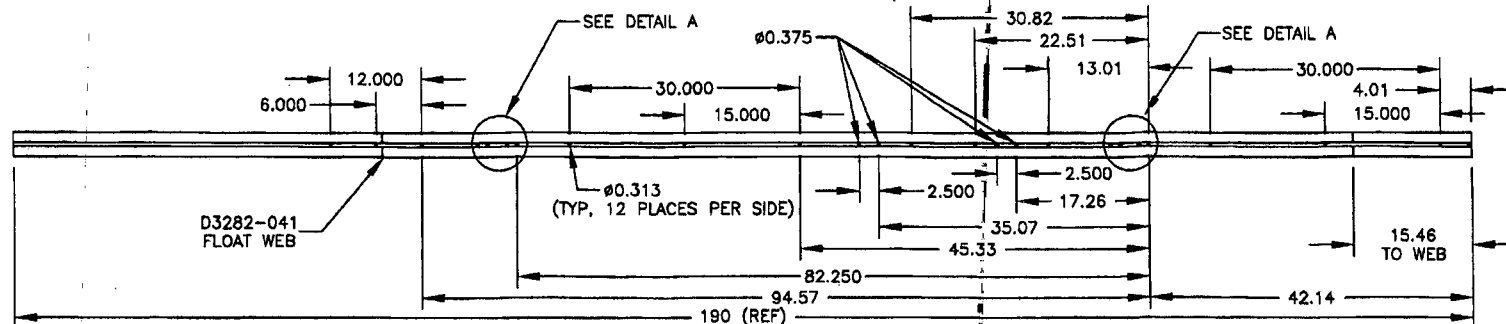
GENERAL NOTES:

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

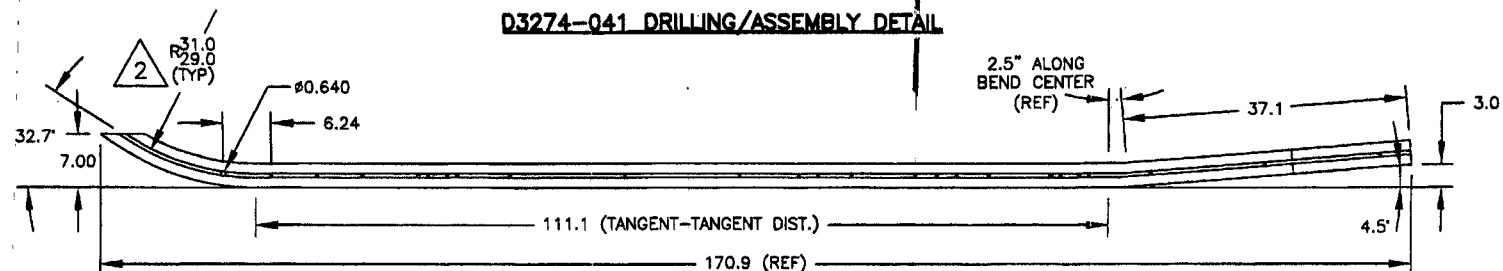
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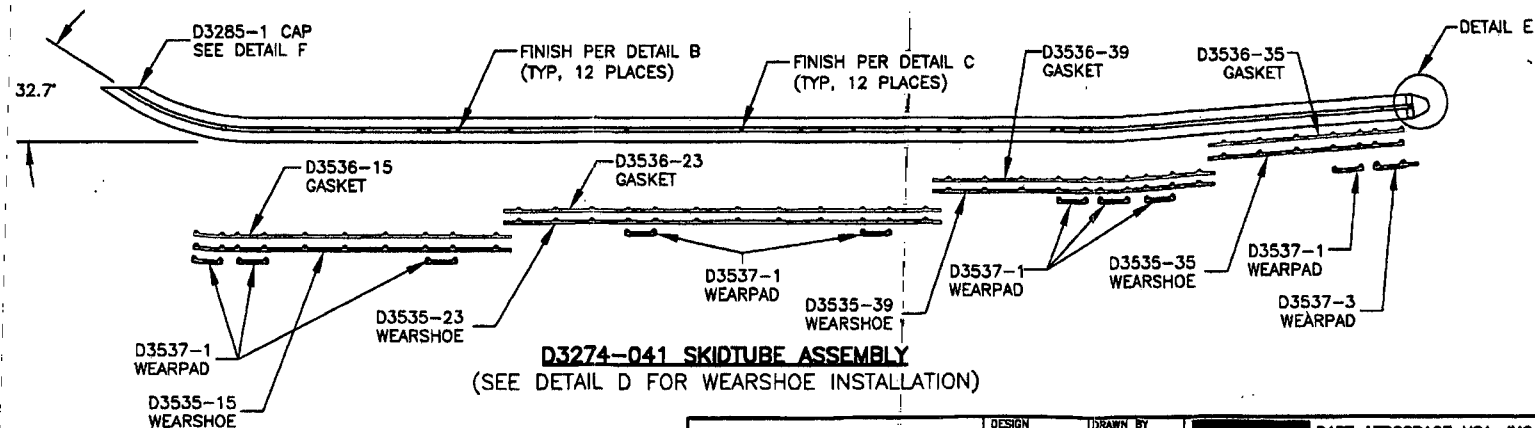
DEO ATTACHED



D3274-041 DRILLING/ASSEMBLY DETAIL



D3274-041 BEND/DRILLING DETAIL



D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

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07.02.12

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


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DESIGN	CP	DRAWN BY	PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	#	APPROVED	#	DRAWING NO. D3274
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	REV. D SHEET 2 OF 4 SCALE 1:15

52807

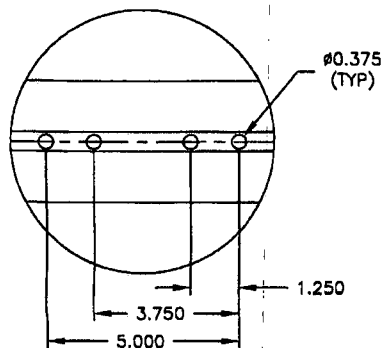


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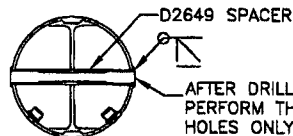
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DATE		TITLE		SCALE	
06.12.19		SKIDTUBE ASSEMBLY		1:15	

52867

DETAIL A: DRILL DETAIL

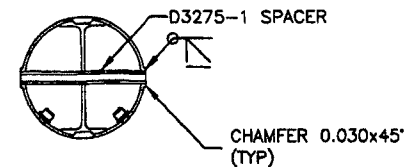


DETAIL B FOR 0.375 HOLES ONLY

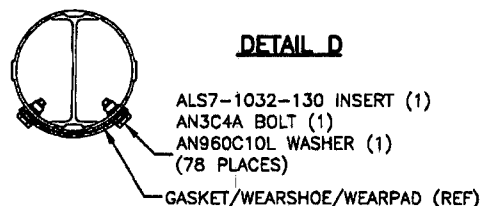


- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR 0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE TO 0.313x0.75 DEEP

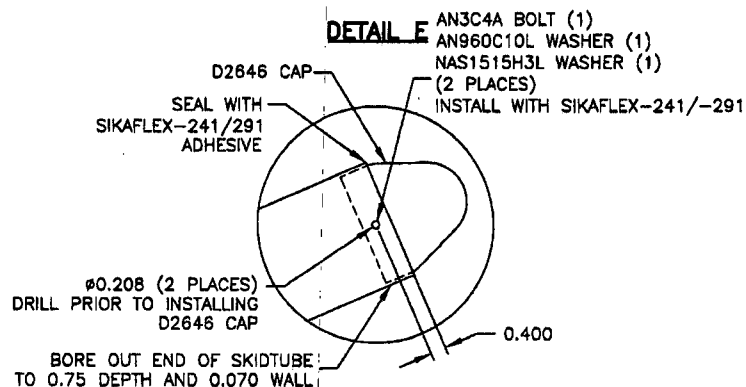
DETAIL C FOR 0.313 HOLES ONLY



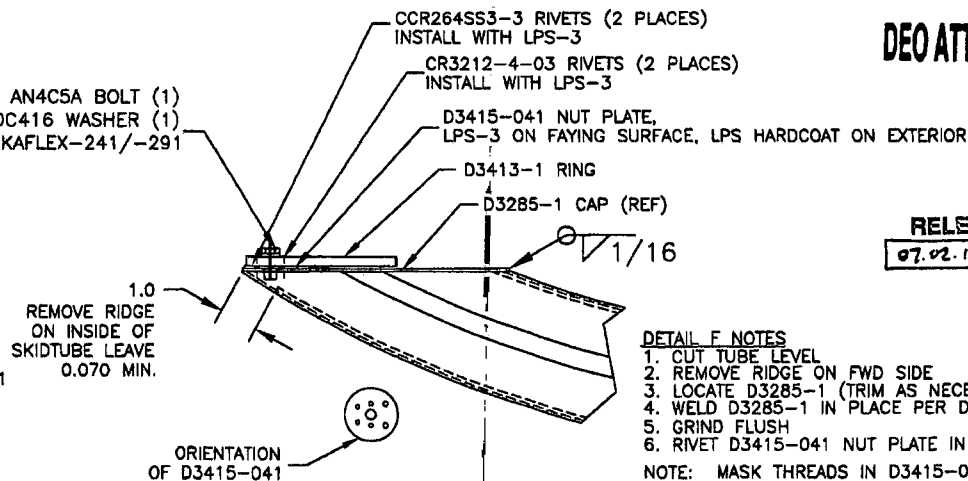
DETAIL D



DETAIL E



DETAIL F: END FINISHING DETAIL



DEO ATTACHED

RELEASED

07.02.12

DETAIL F NOTES

1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D3285-1 (TRIM AS NECESSARY)
 4. WELD D3285-1 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

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CHECKED	CP	APPROVED	PH	DRAWING NO.	REV. D
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	SHEET 4 OF 4	SCALE
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DRAWING NO. D3274	TITLE SKIDTUBE ASSEMBLY	REV. D	DART AEROSPACE USA, INC ENGINEERING ORDER	D.E.O. NO. D3274-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DE APPR. <i>[Signature]</i>		
DATE 09.06.17	DATE 09.06.23	DATE 09/06/23	DATE 09/06/23	DATE 09.06.23		

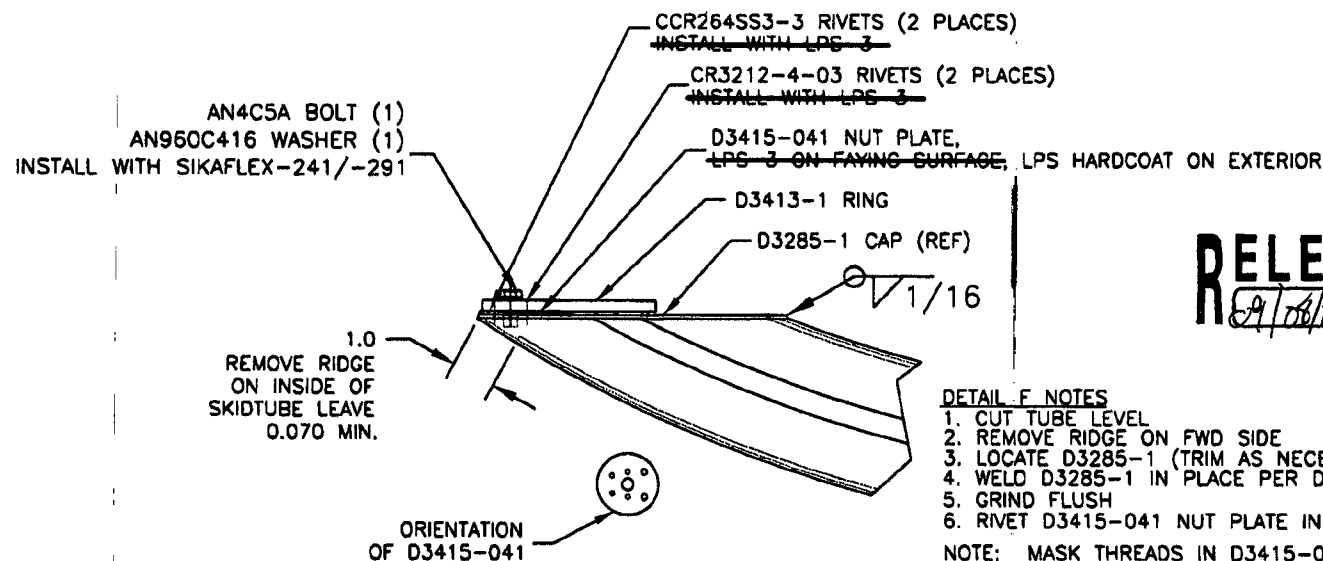
LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

AMEND NOTE 8: "~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES 'LPS-3' AFTER FINISH AND INSTALLATION OF INSERTS.~~
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER."

AMEND DETAIL F AS SHOWN:

52867

DETAIL F: END FINISHING DETAIL



RELEASED
09/06/23

DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

